

Work Order ID 129489

February-12-15 8:53:37 AM

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Item ID: D2199-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 2/12/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference: re-paint *Rework*

Approvals: Process Plan: *U* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2199	F								

130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00

130

Powdercoat
Powder Coating

Memo
PULL FROM TRIAL FIT:
1 X D2199 B103495

SCUFF LIGHTLY
REPOWDER COAT PER DRWG, PER QSI005

START TIME: *8:55*
OVEN TEMPERATURE: *400°*
FINISH TIME: *9:25*

1 \$15.214 **DAS 34 9-89**

140 QC3- Inspect Part Finish 0.00

140

QC
Quality Control

Memo 0.00

DAS 38 28 9-89

FEB 20 2015

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Required Date: 2/12/15 Req'd Qty: 1.00 ***1*** Customer:
Reference: re-paint

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>S132</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

/ FEB 21 2015 DAS
9-89
15/2/23
15-2-23

Picklist Print

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Work Order ID: 129489

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Parent Item: D2199-23

D2199-23

Parent Item Name: Strut

Start Date: 2/12/15

Required Date: 2/12/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: D02.06.10Rem polish & add finishNG/CC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2199-23 *D2199-23* Strut		Manufactured	No				Each	1.0000		1			

**** B103495 (1) 15-2-14**

DAS 34 0.00

Location

Loc Qty

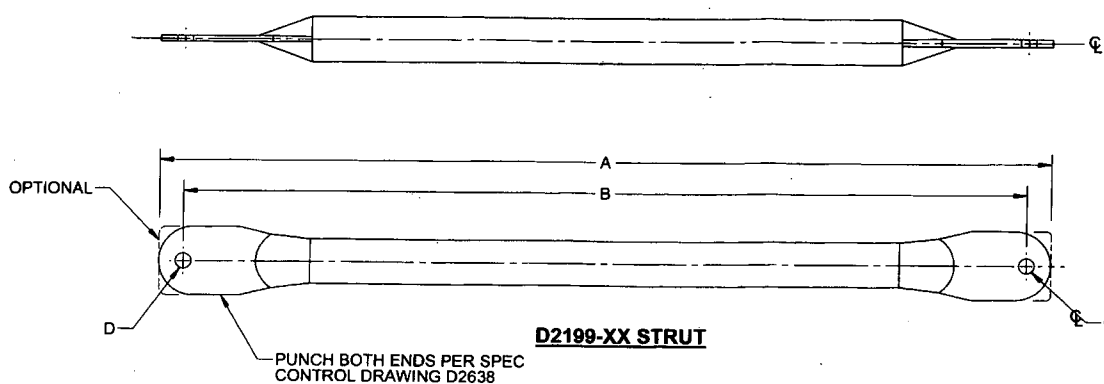
Loc Code

ST352

1

103495

1



PART NUMBER	A	B	C	D	WEIGHT (LBS)	FINISH
D2199-1	18.30	17.50	Ø0.257	Ø0.257	0.56	NOTE 2
D2199-3	5.80	5.00	Ø0.257	Ø0.257	0.17	NOTE 2
D2199-5	22.64	21.84	Ø0.257	Ø0.316	0.69	NOTE 2
D2199-7	14.74	13.94	Ø0.257	Ø0.257	0.45	NOTE 2
D2199-9	16.52	15.72	Ø0.257	Ø0.257	0.50	NOTE 2
D2199-11	23.60	22.80	Ø0.257	Ø0.316	0.72	NOTE 2
D2199-13	15.96	15.16	Ø0.257	Ø0.257	0.49	NOTE 2
D2199-15	17.57	16.77	Ø0.257	Ø0.257	0.54	NOTE 2
D2199-17	28.05	27.25	Ø0.257	Ø0.316	0.86	NOTE 2
D2199-19	18.90	18.10	Ø0.257	Ø0.257	0.58	NOTE 2
D2199-21	10.80	10.00	Ø0.257	Ø0.257	0.33	NOTE 2
D2199-23	26.18	25.38	Ø0.257	Ø0.316	0.81	NOTE 2
D2199-25	19.93	19.13	Ø0.257	Ø0.257	0.61	NOTE 2
D2199-27	27.34	26.54	Ø0.257	Ø0.316	0.84	NOTE 2
D2199-29	21.11	20.31	Ø0.257	Ø0.257	0.65	NOTE 2
D2199-31	15.55	14.75	Ø0.257	Ø0.257	0.45	NOTE 3

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING Ø0.750 X 0.049 WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 REF DART SPEC. M304TR0.750W0.049
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D2199-XX" AND B/N BXXXXXX PER QSI 044, 6.5.
- 8) WEIGHT: PER CHART
- 9) MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER.

RELEASED

2015 FEB 04

REN 15-522 PS-522

F	INCORPORATED E1 REFORMATTED AND REDRAWN. ADDED -31. ADDED GREY SANDTEX FINISH.	AJS	14.09.26
E	ADDED -23 AND -25 PER TSR A565M. ADDED TEMPLATE & SPEC CTRL. DWG REDRAWN IN CAD	KE	98.04.28
D	ADDED -21	N/A	N/A
C	ADDED -17 AND -19	N/A	N/A
B	ADDED -11, -13 AND -15	N/A	N/A
A	NEW ISSUE	JB	1993
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D2199	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT DETAILS	NTS
DATE	14.09.26	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	